Tech-Rod 330

Description

Tech-Rod 330 electrodes are used to weld wrought and cast forms of stainless steels of similar chemical compositions, which offer good heat and scale resistance to 1800°F (980°C). However, high sulfur environments adversely affect the high temperature performance. The heat input has to be kept to a minimum during welding to avoid the possibility of micro-fissuring.

Specifications & Approvals

AWS A5.4 E330-16 UNS W88331 ISO 3581:2003 (18 36)

CWB ASME QSC-395

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	N	S	P	Cu	FN
.21	1.9	.48	BAL	15.45		34.4		*	.023	.021		0

* Nitrogen in these weld deposits is usually between .04% and .08%

Typical Mechanical Properties

Tensile Strength	84,500 PSI	580 MPA
Yield Strength	57,000 PSI	390 MPA
Elongation	26%	

Welding Parameters

			Amperage	
Process	Diameter x Length	Voltage	Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm) 1/8" (3.2mm) x 14" (355mm) 5/32" (4.0mm) x 14" (355mm) 3/16" (4.8mm) x 14" (355mm)	24-28 26-30 28-32 28-32	70-85 85-110 110-140 120-160	65-75 80-90 100-120 110-130

Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb